

Work Order ID 51830

September 4, 2009 9:14:56 AM



Page 1

Item ID: D3846-9

Accept



Setup Start



Revision ID: B

Stop



Item Name: Gasket

Start Date: 09/04/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 09-09-04

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3846	B								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3846								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

IB 9-9-10

(4)

IB 9-9-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

=> 5 or 10/10



QC

Memo

0.00



Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

9/9/10 (4x) 50

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/09/11 [Signature]

Quality Control

u 8.09.4

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Picklist Print

September 4, 2009 9:14:55 AM

Page 1

Work Order ID: 51830



Parent Item: D3846-9RevB



Parent Item Name: Gasket

Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	496.5411	3.5261			
NEOPRENE SHEET 0.063												

7.0522

1B 9-9-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

496.5410585

111469

71.1

111853

96.7589585

112508

328.6821

N/A

112508

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51830
Description: GASKET		Part Number: D3846-9
Inspection Dwg: D3846-9 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
300 X .300	± .010	301 X .301	X			
1.69	± .030	1.689	✓			
2.39	± .030	2.393	✓			
3.26	± .030	3.203	✗			
4.02	± .030	4.024	X			
11.50	± .030	11.50	✗			
9.00	± .030	9.00	X			
18.00	± .030	18.00	*			
27.00	± .030	27.00	*			
36.00	± .030	36.00	*			
60.00	± .030	60.00	*			
14.49	± .030	14.49	X			
25.48	± .030	25.48	X			
28.98	± .030	28.32	✗			
49.32	± .030	49.32	*			
52.82	± .030	52.82	✓			
54.44	± .030	54.44	✓			
57.94	± .030	57.94	✓			
.063	± .010	.064	✓			

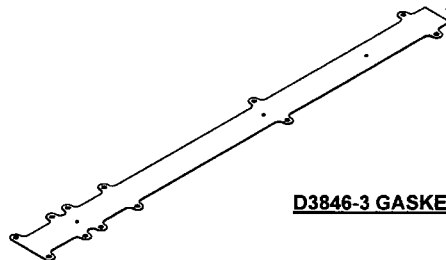
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-10	Date: 09/09/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

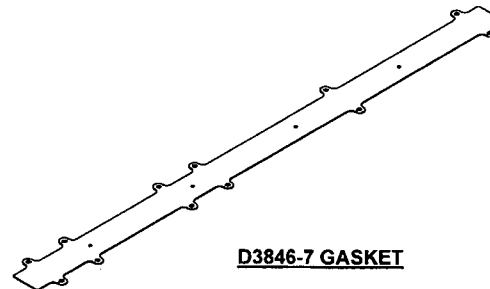
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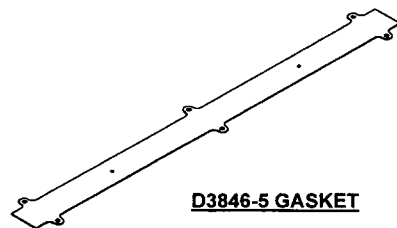
D3846-1 GASKET



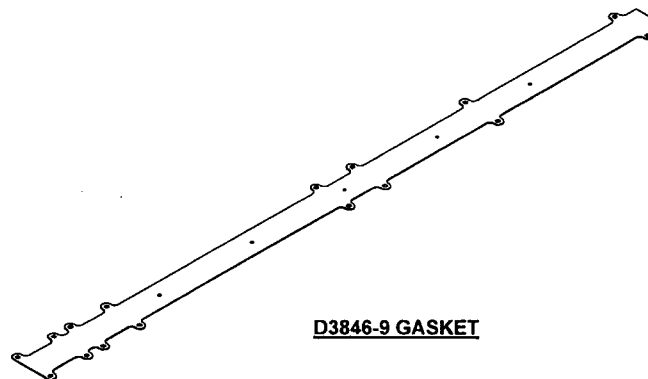
D3846-3 GASKET



D3846-7 GASKET



D3846-5 GASKET



D3846-9 GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51830
mf
09-09-04



D3846-11 GASKET

RELEASED
09/07/05

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3846-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:
D3846-1 = 0.03 lbs
D3846-3 = 0.25 lbs
D3846-5 = 0.20 lbs
D3846-7 = 0.26 lbs
D3846-9 = 0.35 lbs
D3846-11 = 0.04 lbs

B	5.82 WAS 6.25 (ZN C4-2); 45.28 WAS 45.71 (ZN A4-3); 6.32 WAS 6.75 (ZN B2-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3846	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GASKET	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

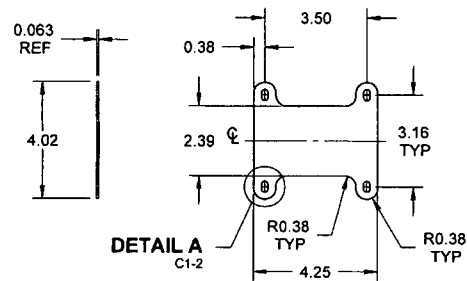
W/O:		WORK ORDER CHANGES					
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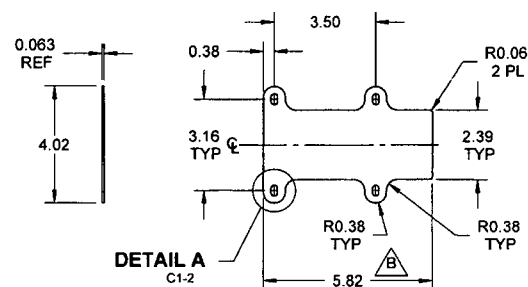
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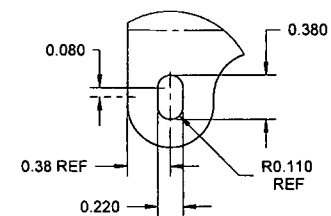
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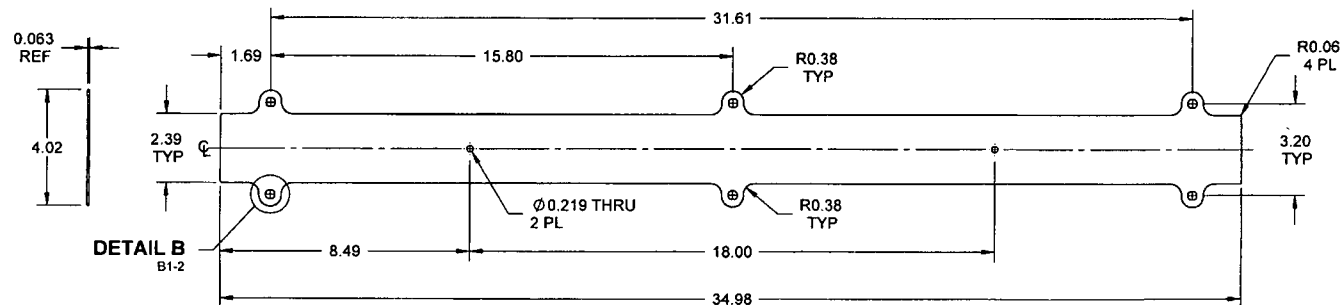
D3846-1 GASKET



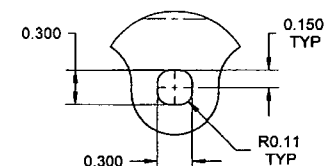
D3846-11 GASKET



DETAIL A C5-2
TYP. SCALE 4X C7-2



D3846-5 GASKET



DETAIL B A7-2
TYP. SCALE 4X C5-3
B7-3 C5-4

RELEASED
09/07/15

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APPROVED	<i>NP</i>	TITLE	SCALE
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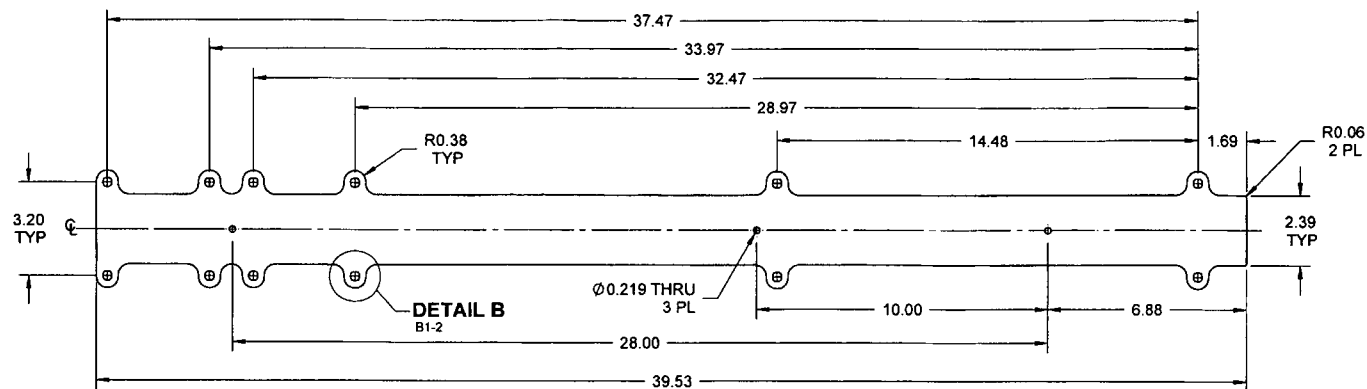
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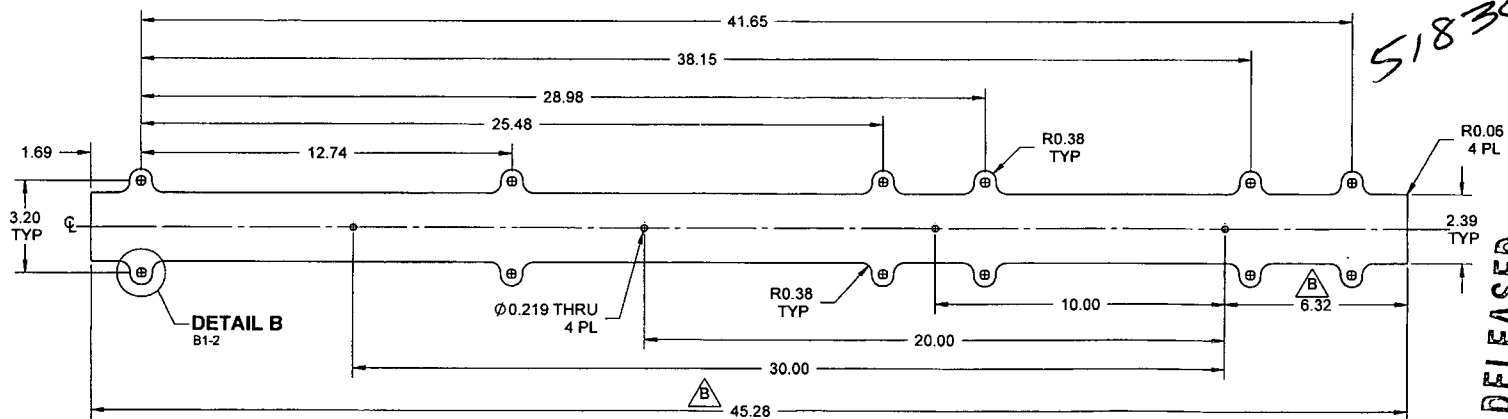
NOTE: Date & initial all entries

0.063
REF
4.02



D3846-3 GASKET

0.063
REF
4.02



D3846-7 GASKET

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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3846	SHEET 3 OF 4
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RELEASED
2015/15/14

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

C

B

B

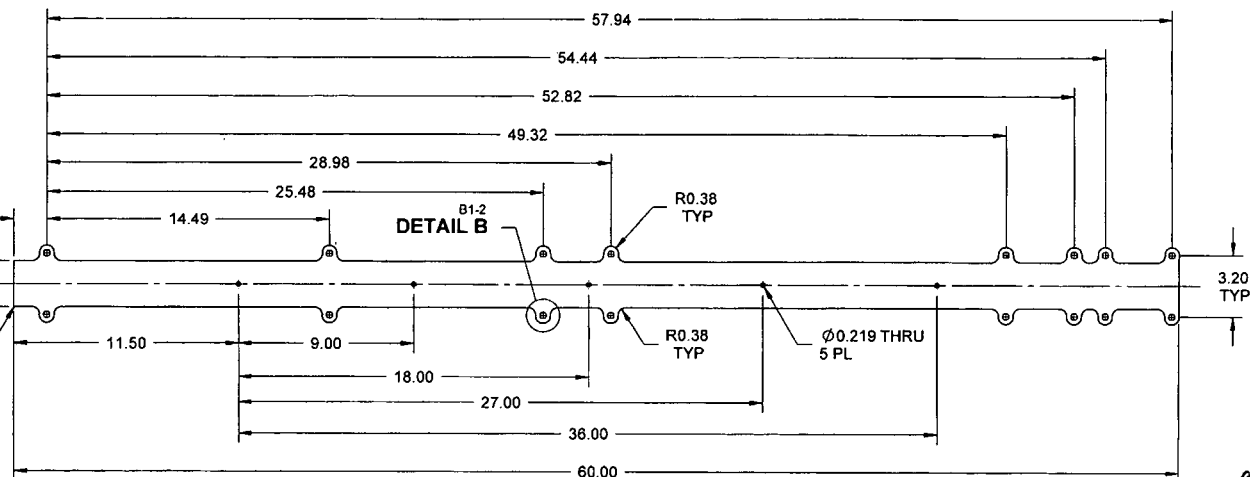
A

A

0.063
REF

4.02

1.69
2.39
TYP
R0.06
2 PL



D3846-9 GASKET

RELEASED
2010/11/15

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3846	REV. B SHEET 4 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE GASKET	SCALE NTS
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8 7 6 5 4 3 2 1

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